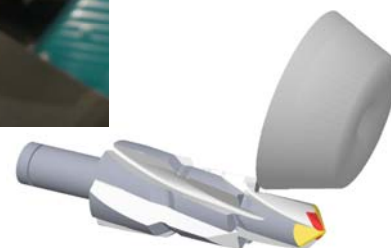
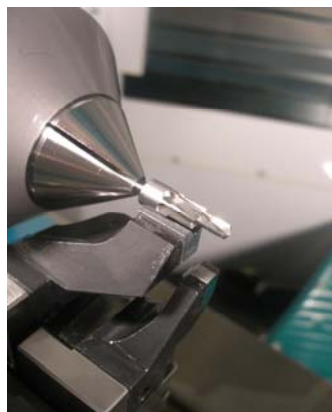



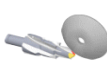










Dental Stepdrill Z6-Z3 Ø4.8 Z6

A26-510

The grinding operations to be done on this special dental drill are similar to resharpening operations on a premachined blank. Flutes and cylindrical OD's are therefore already done. The fully automatic grinding of the tool with the intergrated Fanuc Robot is supported with the MicroTool Steadyrest.



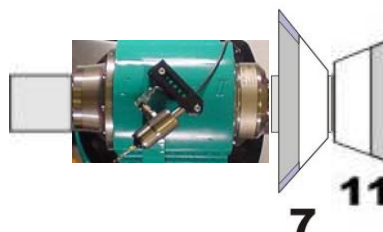
1. Cycletime for Production

Tool specifications							
Diameter 4.8 mm, Z 6, Length of cutting edge 7.8 mm, Helix angle 15°							
Material HSS							
Operations							
Feed [mm/Min]	2000	100	100	130	120	120	9000
Power [kW]		2	1	1	1	1	1
Cutting feed [m/s]		32	32	32	32	32	
Used wheels							
Grinding time [s]	13	23	28	25	114	126	13
Total cycle time	5 Min 41						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

7	12V9 Ø125 B76
11	11V9 Ø100 B76



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG, STL 650
 Control: Fanuc 160i
 Coolant: Synthetic Oil, pressure 6 bar
 Software: Quinto 4 & 5

responsible engineer: OP,27.3.09

www.schneeberger.ch

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